

Work Order ID 71924

Wednesday, July 13, 2011 12:48:51 PM



Item ID: D3075-1

Accept



Setup Start



Revision ID:

Stop



Item Name: R44 Bearpaw

Start Date: 7/13/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

YMF

Date:

11-07-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3075

Rev B

110

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3075-1_BLANK

UHMW

B11-8-16

7

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit: 11-Inspect material for defects or damage prior to machining; 12-Machine as per Folio FA185 and Dwg D3076Identify as D3075-1113-Deburr

22 11-7-14 B

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

22 11-7-14 B

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC8- Inspect parts - second check

0.00

2 11-09-14



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PN 71925

0.00

Packaging

6X
1X5TONE

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/10 (7)

11/9/10

MF
11-09-15

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Picklist Print

Wednesday, July 13, 2011 12:48:48 PM

Page 1

Work Order ID: 71924

Parent Item: D3075-1

Parent Item Name: R44 Bearpaw



Start Date: 7/13/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 -KJ/JLM
 IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	612.8000	1	6			



UHMW 1" Black



B11-8-15

7

Location

Loc Qty

Loc Code

MAT018

612.8

117321

76.6

117738

166.3

117819

129.9

118257

240

117738

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DART AEROSPACE LTD		Work Order: 71924
Description: R44 Bearpaw		Part Number: D3075-1
Inspection Dwg: D3075	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.06	/		Rq. 02	
B	0.63	+/-0.030	.641	/		Rq. 15	
C	0.250	+/-0.010	.260	/			
D	0.950	+0.030/-0.010	.957	/			
E	5.50	+/-0.030	5.501	/			
F	0.25 x 45°	+/-0.030	.260	/			
G	0.900	+/-0.010	.902	/			
H	0.375	+/-0.010	.381	/			
I	1.30	+/-0.030	1.298	/			
J	5.70	+/-0.030	5.70	/			
K	0.37	+/-0.030	.381	/			
L	3.600	+/-0.010	3.600	/			
M	0.260	+0.005/-0.000	.260	/			
N	0.93	+/-0.030	.923	/			
O	0.30	+0.030/-0.000	.302	/			
P	1.08	+/-0.030	1.078	/			
Q	5.870	+/-0.010	5.863	/			
R	10.14	+/-0.030	10.145	/			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11.9.14	Date: 11-09-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD [Signature]	[Signature]

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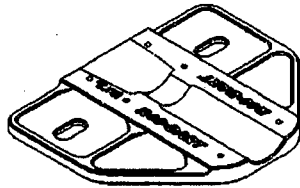
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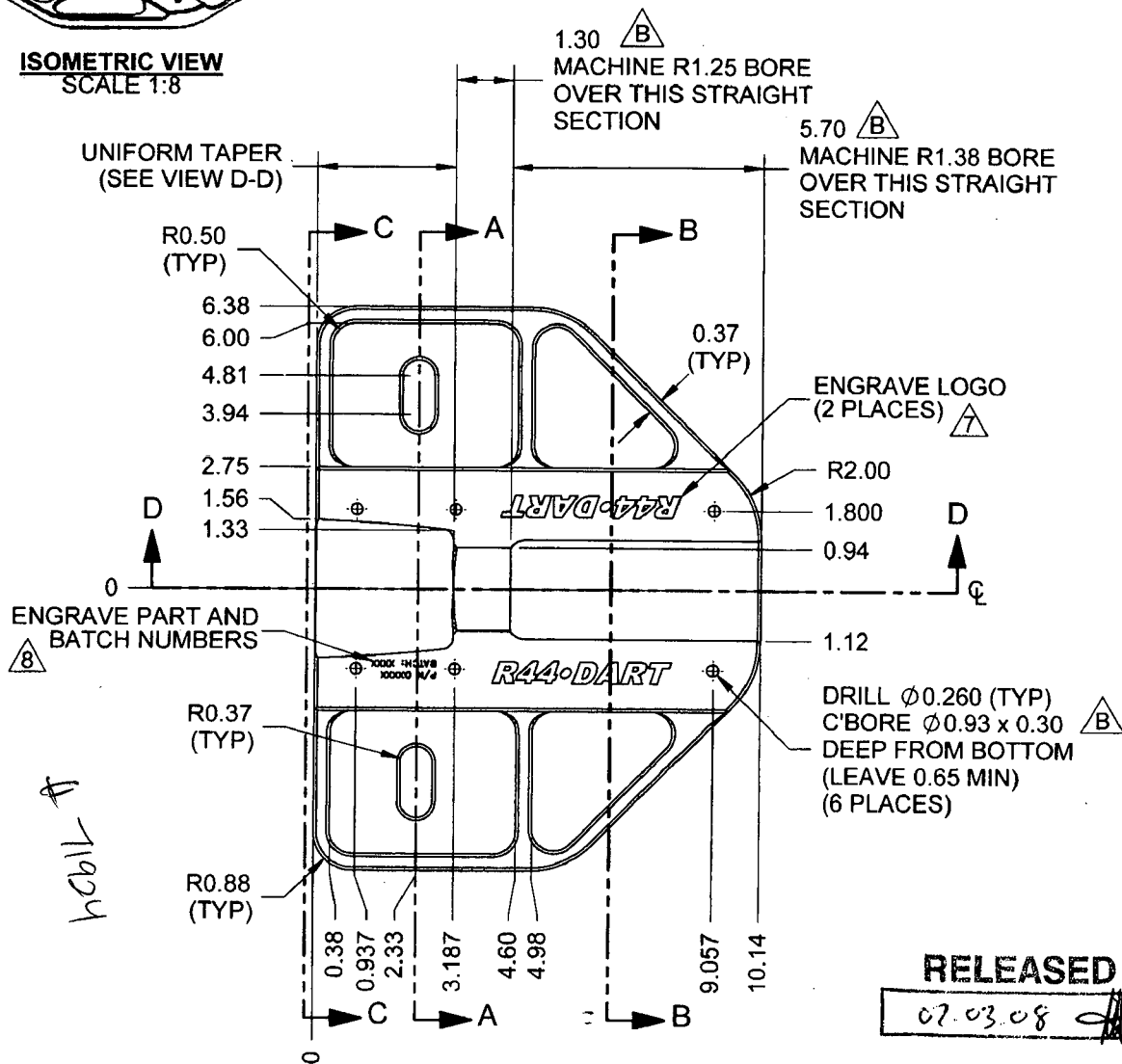
NOTE: Date & initial all entries



DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED #3	APPROVED #1	DRAWING NO. D3075
DATE 07.02.27	TITLE R44 BEARPAW	REV. B SHEET 1 OF 2
REV A	DATE 02.01.04	DESCRIPTION NEW ISSUE
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)



ISOMETRIC VIEW
SCALE 1:8



D3075-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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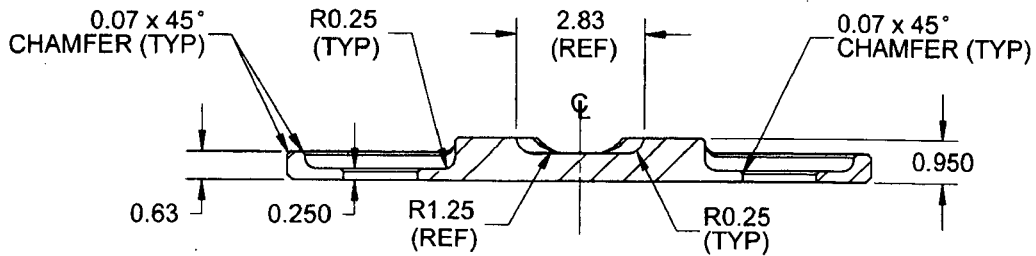
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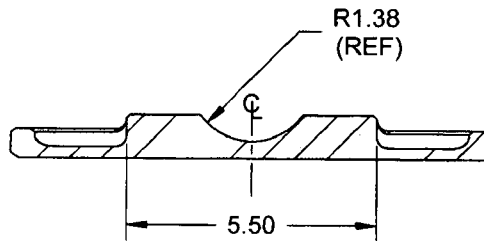
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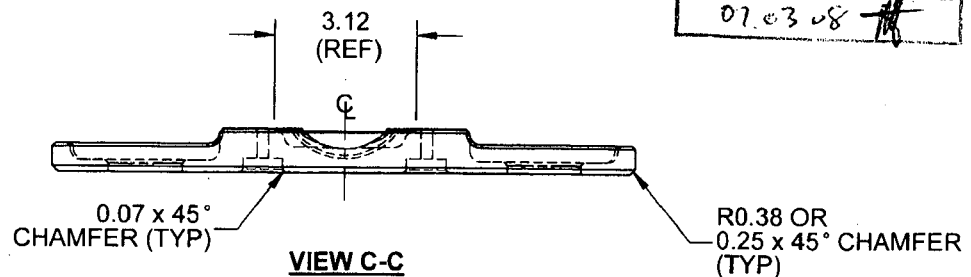
DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4



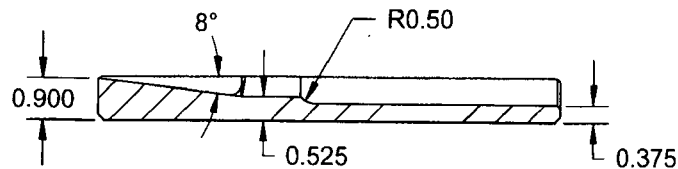
SECTION A-A



SECTION B-B



VIEW C-C



SECTION D-D

RELEASED

07.03.08

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